

Work Order ID 69696

Monday, May 16, 2011 3:10:34 PM



Page 1

Item ID:	D3580-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Joggle Bracket					
Start Date:	5/16/2011	Start Qty:	40.00		Cust Item ID:	
Required Date:	5/18/2011	Req'd Qty:	40.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-05-16	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3580	Rev B								

100		0.00							
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	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3580								
304 . 050	Dwg Rev:								
	Prog Rev:								
	2-Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
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QC	Memo	0.00							
Quality Control									

8/11/16/17

LOCATED

(X60)

B 11-5-16

(60)

(15)

1311-576

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Monday, May 16, 2011 3:10:34 PM

Item ID: D3580-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Joggle Bracket

Start Date: 5/16/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 5/18/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00				(60)			
Small Fab	Memo	0.00		SB 11/05/18					
Small Fab	Bend as per dwg D3580 using 1/8" offset die								
140 QC	QC5- Inspect part completeness to step on W/O	0.00				count (x60)			
Quality Control	Memo	0.00		8/11/19					
150 Packaging	Identify as per dwg & Stock Location: 68	0.00							
Packaging	Memo	0.00				11/5/19 (600 SP)			

W/O:		WORK ORDER CHANGES					
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Item ID: D3580-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Joggle Bracket

Start Date: 5/16/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 5/18/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

N 15/19 DJ

N 11-0519
(40)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, May 16, 2011 3:10:42 PM

Page 1

Work Order ID: 69696



Parent Item: D3580-1



Parent Item Name: Joggle Bracket

Start Date: 5/16/2011

Required Date: 5/18/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev :A New Issue 07.06.25 EC
IPP Rev:B Removed Powder Coat 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	181.0000	0.01	0.421053			



304/316 .050 Sheet



HB11-5-11

Location

Loc Qty

Loc Code

MAT020

181

112178

4

113062

18

116135

20.5

116604

1.5

116979

69

117653

68

117653

W/O:		WORK ORDER CHANGES					
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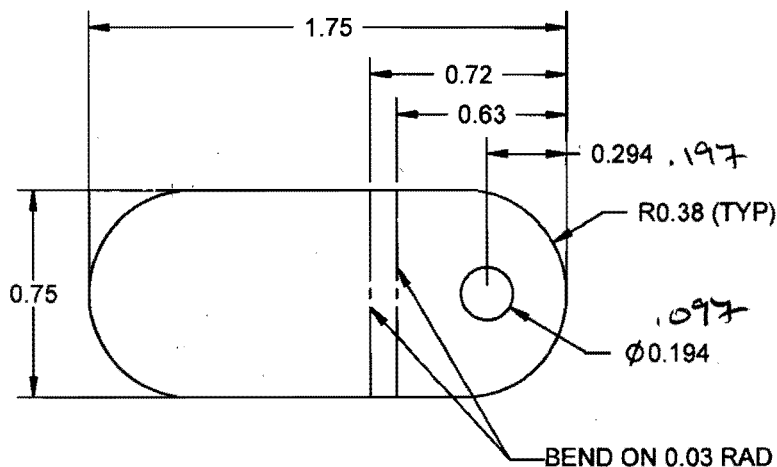


DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3580	REV. B SHEET 1 OF 1
DATE 07.07.09		TITLE JOGGLE BRACKET	SCALE 3:2
REV	DATE	DESCRIPTION	
A	07.05.15	NEW ISSUE	
B	07.07.09	REMOVE POWDER COAT	

RELEASED

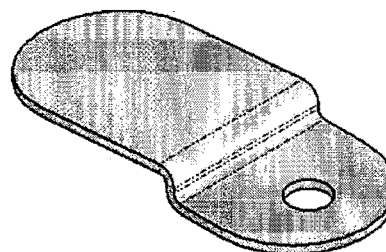
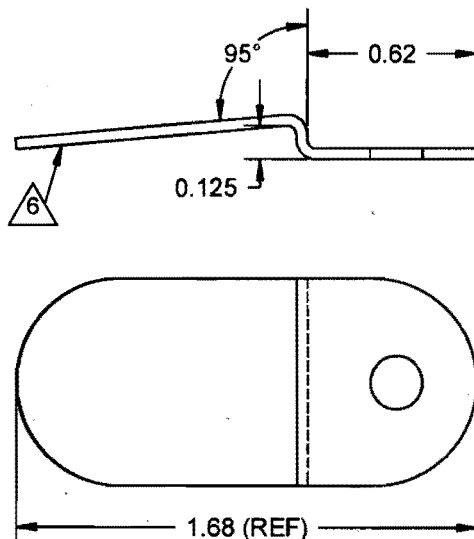
07.07.09 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *69694*



D3580-1F FLAT PATTERN

11-05-10



D3580-1 JOGGLE BRACKET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER
ON THE UNDERSIDE OF THE PART AS INDICATED

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